

**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)**  
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

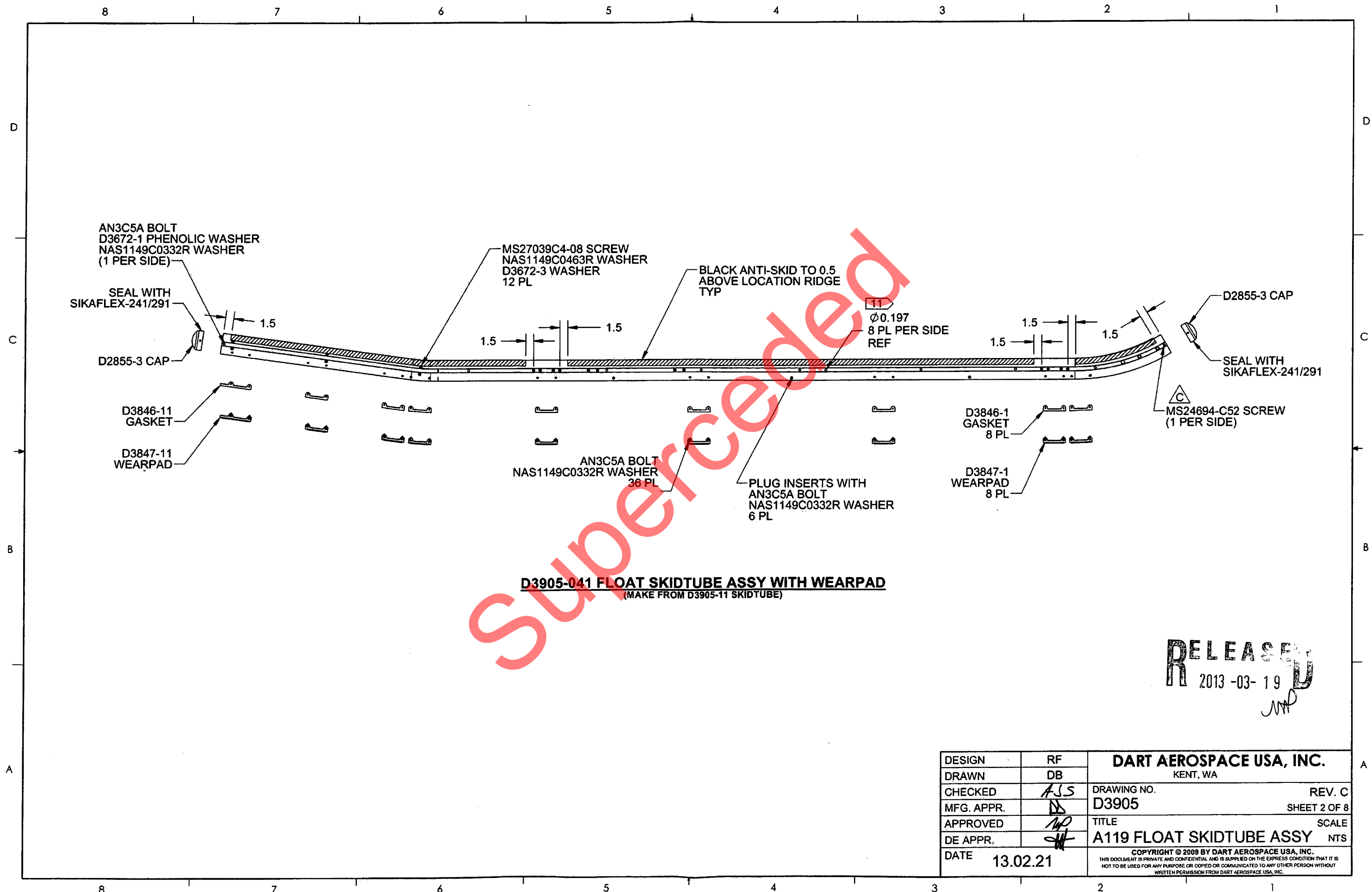
**NOTES:**

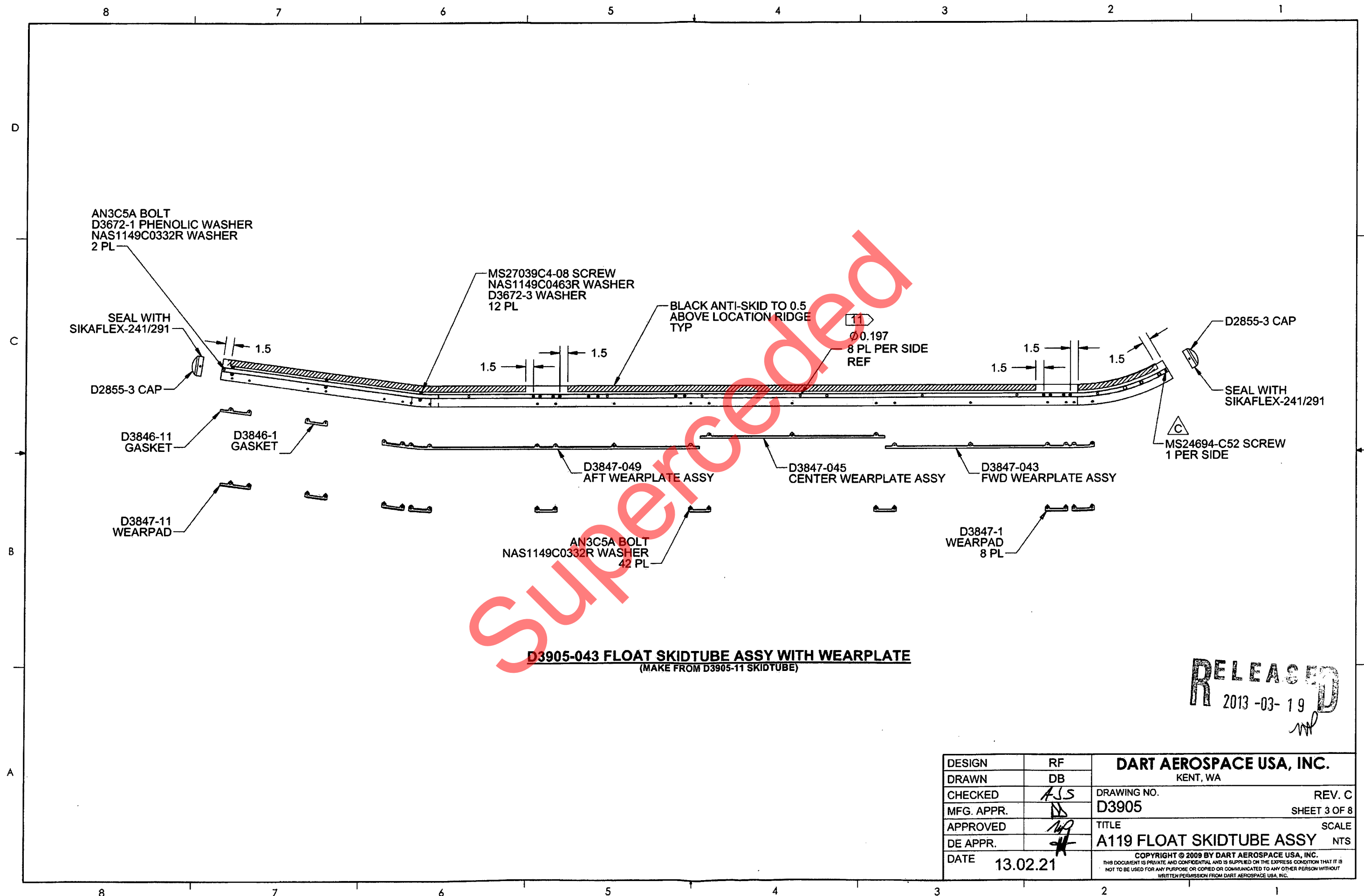
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs  
D3905-043 = 47.0 lbs  
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO  $\phi 0.197$  HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL  $\phi 0.297$  HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

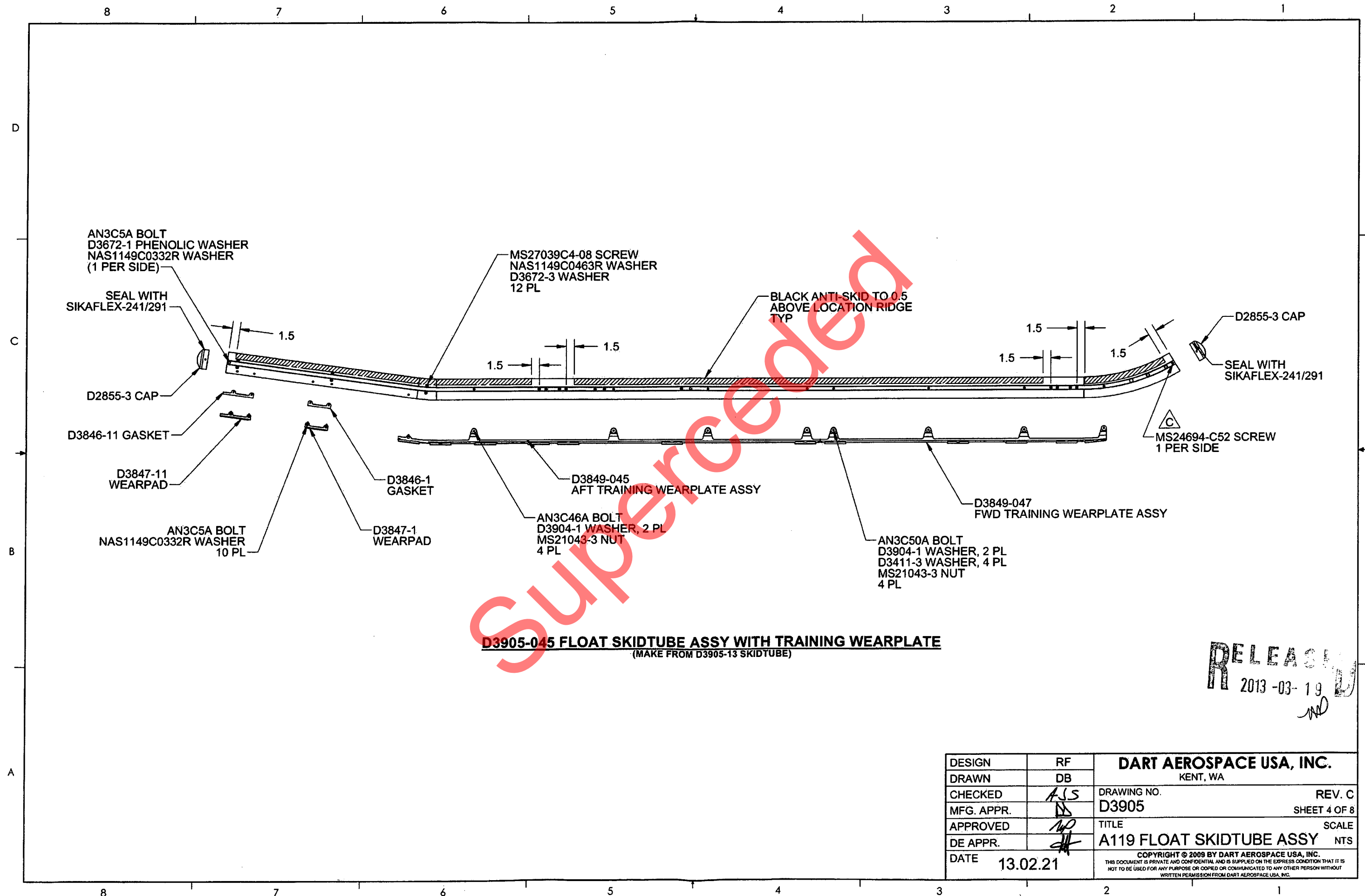
| ITEM | QTY<br>-041 | QTY<br>-043 | QTY<br>-045 | P/N           | DESCRIPTION                                 |
|------|-------------|-------------|-------------|---------------|---|
| 1    | X           |             |             | D3905-041     | FLOAT SKIDTUBE ASSY WITH WEARPAD            |
| 2    |             | X           |             | D3905-043     | FLOAT SKIDTUBE ASSY WITH WEARPLATE          |
| 3    |             |             | X           | D3905-045     | FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE |
| 10   | 2           | 2           | 2           | D2579         | CROSS BOLT SPACER                           |
| 11   | 2           | 2           | 2           | D2855-3       | CAP   |
| 12   | 16          | 16          |             | D3492-045     | PLUG ASSY                                   |
| 13   | 2           | 2           | 2           | D3672-1       | PHENOLIC WASHER                             |
| 14   | 8           | 8           | 8           | D3681-1       | SPACER                                      |
| 15   | 8           | 1           | 1           | D3846-1       | GASKET                                      |
| 16   | 1           | 1           | 1           | D3846-11      | GASKET                                      |
| 17   | 8           | 8           | 1           | D3847-1       | WEARPAD                                     |
| 18   | 1           | 1           | 1           | D3847-11      | WEARPAD                                     |
| 19   |             | 1           |             | D3847-043     | FWD WEARPLATE ASSY                          |
| 20   |             | 1           |             | D3847-045     | CENTER WEARPLATE ASSY                       |
| 21   |             | 1           |             | D3847-049     | AFT WEARPLATE ASSY                          |
| 22   |             |             | 1           | D3849-047     | FWD WEARPLATE ASSY                          |
| 23   |             |             | 1           | D3849-045     | AFT WEARPLATE ASSY                          |
| 24   | 1           | 1           | 1           | D3885-3       | FLOAT WEB                                   |
| 25   | 1           | 1           |             | D3905-11      | FLOAT SKIDTUBE                              |
| 26   |             |             | 1           | D3905-13      | FLOAT SKIDTUBE                              |
| 27   | 12          | 12          | 12          | D3903-1       | SPACER                                      |
| 28   |             |             | 16          | D3904-1       | WASHER                                      |
| 29   | 12          | 12          | 12          | D3672-3       | WASHER                                      |
| 30   | 12          | 12          | 12          | D3683-3       | INSERT                                      |
| 31   |             |             | 16          | D3411-3       | WASHER                                      |
| 41   | 42          | 42          | 10          | ALS4-1032-130 | INSERT                                      |
| 42   | 44          | 44          | 12          | AN3C5A        | BOLT  |
| 43   |             |             | 4           | AN3C46A       | BOLT  |
| 44   |             |             | 4           | AN3C50A       | BOLT  |
| 45   | 44          | 44          | 8           | NAS1149C0332R | WASHER (OR AN960C10L)                       |
| 46   | 12          | 12          | 12          | NAS1149C0463R | WASHER (OR AN960C416)                       |
| 47   |             |             | 8           | MS21043-3     | NUT   |
| 48   | 12          | 12          | 12          | MS27039C4-08  | SCREW                                       |
| 49   | 2           | 2           | 2           | MS24694-C52   | SCREW                                       |

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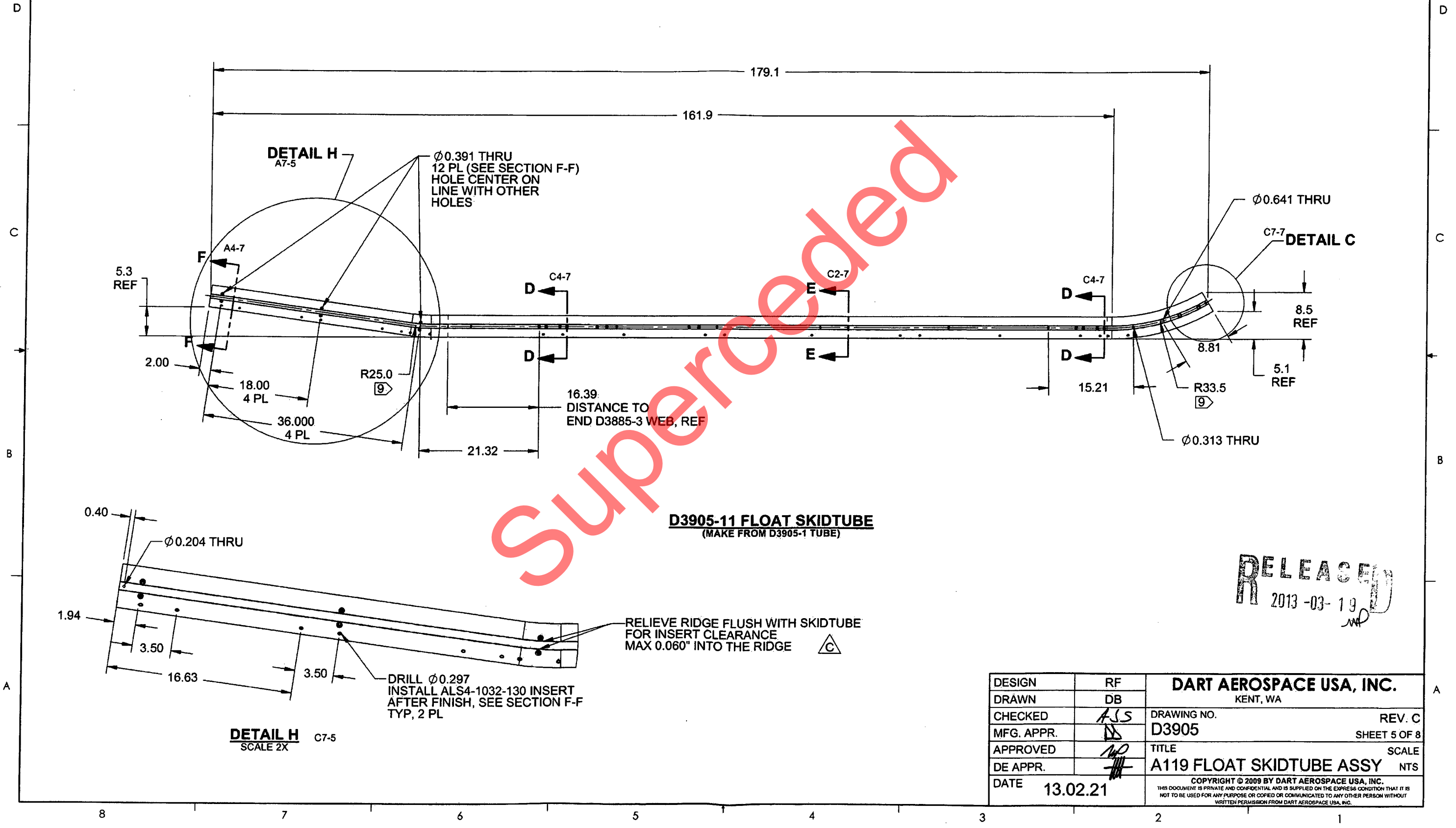
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|------------|---|---|--------------|
| C          | (SHT 1 P/L, ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 46, ADD ITEM 49, MS24694-C52 WAS AN3C5A, D3672-1 AND NAS1149C0332R, (ZN C7-7) $\phi 0.201$ CSK $\phi 0.385 \times 100$ WAS $\phi 0.204$ THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C6-7, D8-7)  | DB  | 13.02.21     |
| B          | REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); $\phi 0.313$ WAS $\phi 0.328$ (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE iv (ZN A8-7) | RF  | 09.06.30     |
| A          | NEW ISSUE   | RF  | 09.03.30     |
| REV.       | DESCRIPTION   | BY  | DATE         |
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| APPROVED   | MD  | TITLE   | SCALE        |
| DE APPR.   | TH  | A119 FLOAT SKIDTUBE ASSY NTS  |              |
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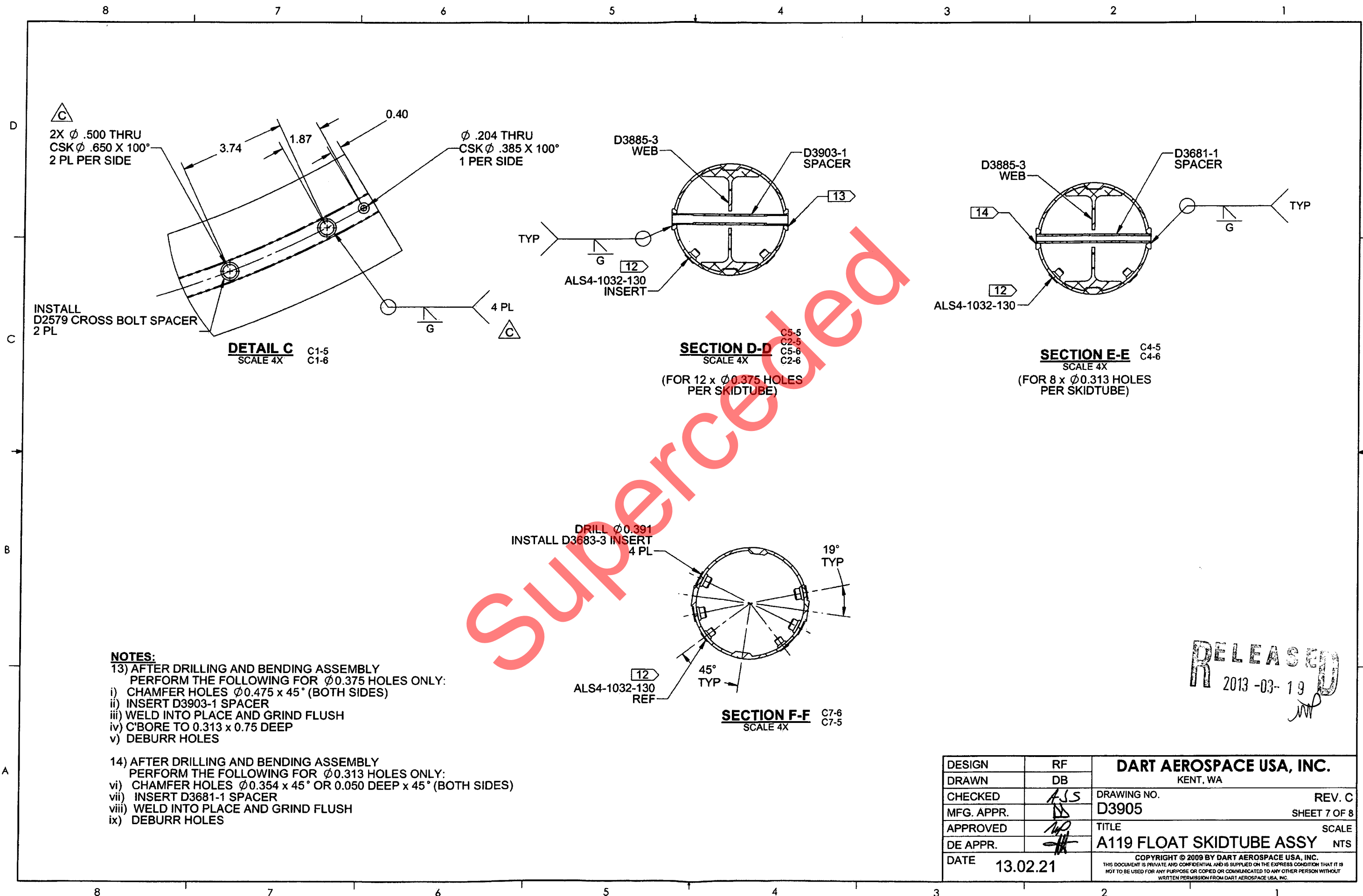


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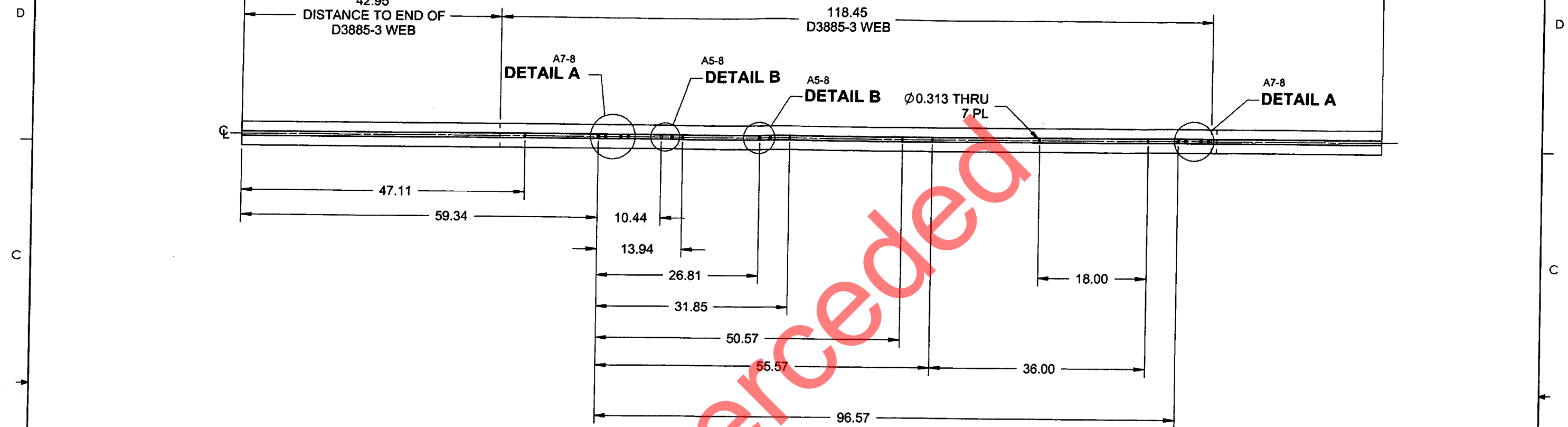


- NOTES:**
- 13) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.375$  HOLES ONLY:
- i) CHAMFER HOLES  $\phi 0.475 \times 45^\circ$  (BOTH SIDES)
  - ii) INSERT D3903-1 SPACER
  - iii) WELD INTO PLACE AND GRIND FLUSH
  - iv) C'BORE TO  $0.313 \times 0.75$  DEEP
  - v) DEBURR HOLES
- 14) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.313$  HOLES ONLY:
- vi) CHAMFER HOLES  $\phi 0.354 \times 45^\circ$  OR  $0.050$  DEEP  $\times 45^\circ$  (BOTH SIDES)
  - vii) INSERT D3681-1 SPACER
  - viii) WELD INTO PLACE AND GRIND FLUSH
  - ix) DEBURR HOLES

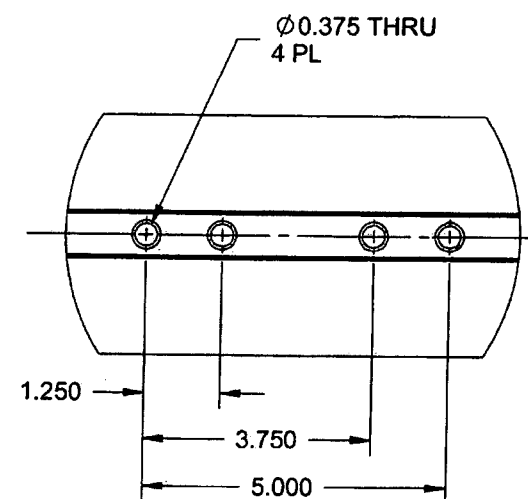
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| MFG. APPR. | DB       | SHEET 7 OF 8  |        |
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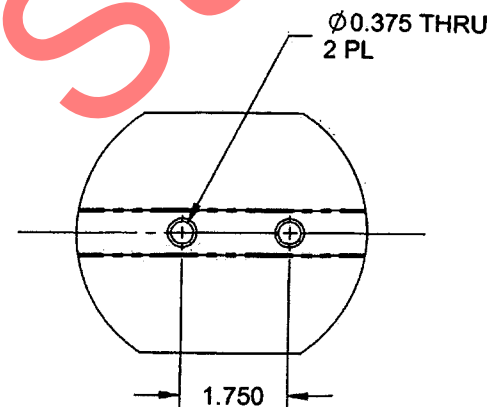
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**D3905-1 TUBE**  
(MAKE FROM D2500-1-190 EXTRUSION)



**DETAIL A**  
SCALE 4X  
D6-8  
D2-8



**DETAIL B**  
SCALE 4X  
D5-8  
D4-8

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| MFG. APPR. | DS       |  | SHEET 8 OF 8 |
| APPROVED   | W        | TITLE<br><b>A119 FLOAT SKIDTUBE ASSY</b>   | SCALE<br>NTS |
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